

Work Order ID 96957

February-13-13 7:33:27 AM

96957

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Item ID: D2596

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Web. 205 Skidtube

Stop *NS2*

Start Date: 2/13/13 Start Qty: 3.00

3

Cust Item ID:

Required Date: 2/20/13 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: ML5

Date: 13-02-13 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2596 | Rev D | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | Skidtubes | | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr | | | | | | | | |
| 110 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

3 x CF 13-2-13

3 x CF 13-2-14

DA 03 89
③ 13-2-14

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Item ID: D2596

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web. 205 Skidtube

Start Date: 2/13/13 Start Qty: 3.00 ***3***

Cust Item ID:

Required Date: 2/20/13 Req'd Qty: 3.00 ***3***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***

QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---|
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: 46 Memo | 0.00 0.00 | | | | | | | DP 13-2-14 |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | 13/2/14 mf 13-2-15 |

Picklist Print

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Page 1

Work Order ID: 96957

96957

Parent Item: D2596

D2596

Parent Item Name: Web. 205 Skidtube

Start Date: 2/13/13

Required Date: 2/20/13

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2500-3-100 | | Manufactured | No | | | 100 | Each | 238.0000 | 1 | 3 | | | |
| *D2500-3-100* | | | | | | | | | | ** | PF 13-2-13 | | |
| Ext'n - 'I' Beam Web 4" | | | | | | | | | | | | | |

Location

Loc Qty

Loc Code

LG

238

84873

4

89110

234

3

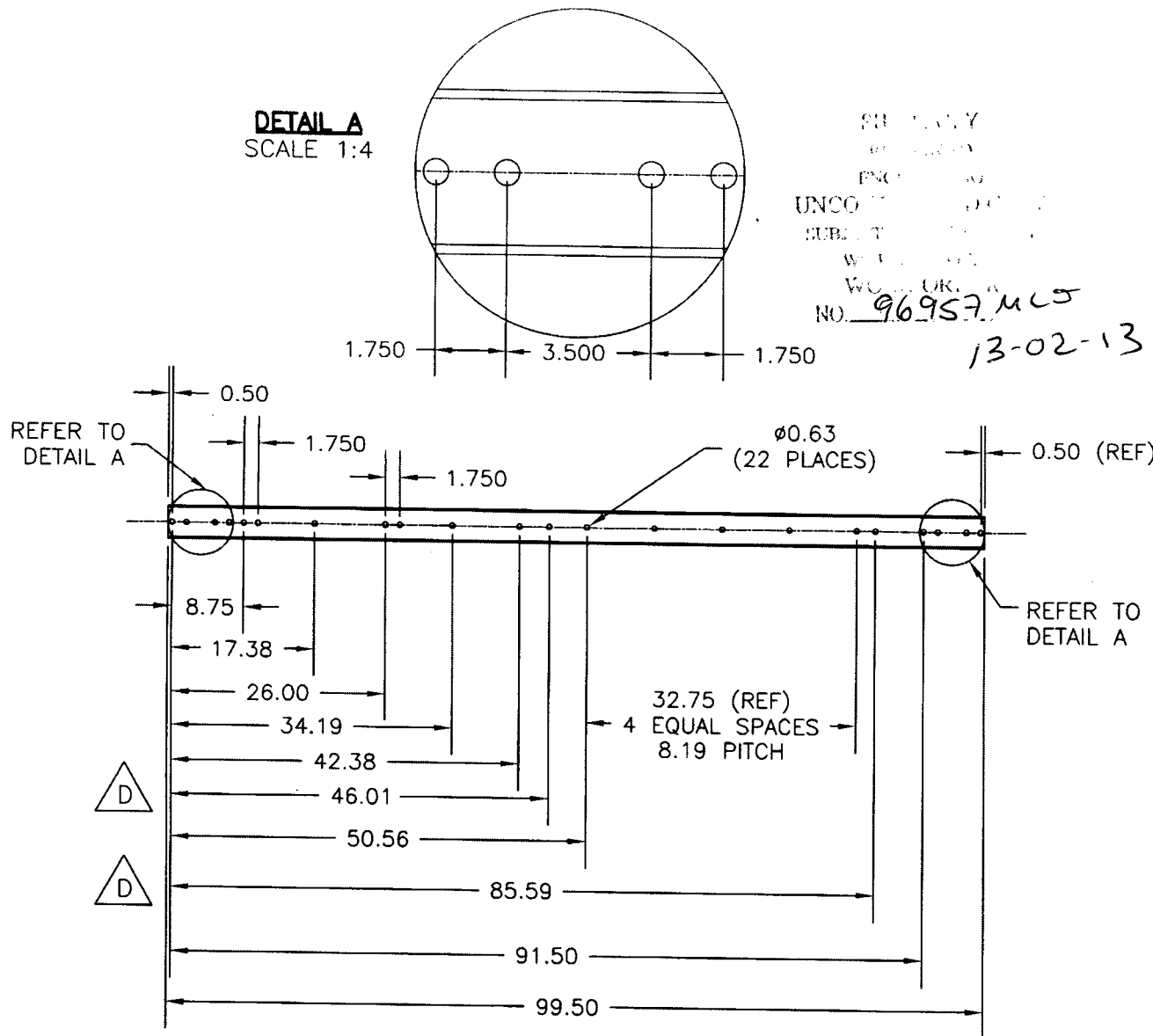
DART

RELEASED
07.06.18

| | | | | |
|---------|----------|----------|-----------------------|-----------------------------|
| DESIGN | RA | DRAWN BY | DT | DART AEROSPACE LTD |
| CHECKED | | APPROVED | | HAWKESBURY, ONTARIO, CANADA |
| DATE | 07.04.17 | TITLE | D2596 | REV. D |
| | | | 205 WEB | SHEET 1 OF 1 |
| | | | NEW ISSUE | SCALE 1:20 |
| | | | 0.63 HOLE WAS 0.56 | |
| | | | INCORPORATED DEO 9097 | |
| | | | INCORPORATED DEO 9183 | |

SUBJECT: UNCO...
SUBJECT: ...
NO. 96957 MLC
13-02-13

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020